

# Work Order ID 64775

Friday, December 17, 2010 7:49:20 AM



Page 1

Item ID: D2583

Accept



Setup Start



Revision ID:

Item Name: Latch Bracket

Stop



Start Date: 12/16/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: *12-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-  
Debur if necessary

*5052.040*

*B11-1-3*

*24*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B11-1-3*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Silaloz*

*count*  
*x24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Item ID: D2583	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Latch Bracket				
Start Date: 12/16/2010	Start Qty: 20.00		Cust Item ID:	
Required Date: 1/19/2011	Req'd Qty: 20.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	<i>M 1150151</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:25</i> FINISH TIME: <i>3:55</i> OVEN TEMPERATURE:								

*24 BR 10-01-5*

170	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

*=> M 11/01/06*

*24 0*

180	Identify as per dwg & Stock Location: <i>017</i>	0.00							
Packaging	Memo	0.00							
Packaging									

*Emp/6 (24)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 64775**

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Item ID:	D2583	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Latch Bracket					
Start Date:	12/16/2010	Start Qty: 20.00		Cust Item ID:		
Required Date:	1/19/2011	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

CAK 11/01/06.  
MF  
11-01-06

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, December 17, 2010 7:49:25 AM

Page 1

Work Order ID: 64775

Parent Item: D2583

Parent Item Name: Latch Bracket



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C100.11.01 [Removed P/O for Powder Coat- in house process] DM  
IPP: D106.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	60.0234	0.1169	2.461053	2.9		
5052-H32 .040 Sheet													



11611-1-3

Location	Loc Qty	Loc Code
MAT	57	
114488	12	
116405	45	
MAT23	3.0234	
109058	1.6234	
113123	1.4	

116405

24

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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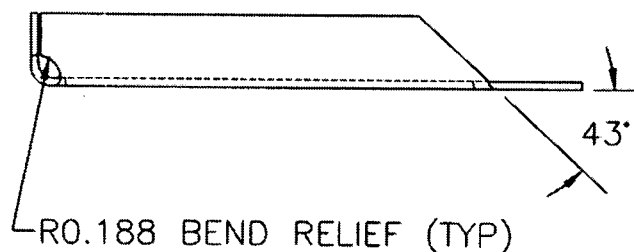
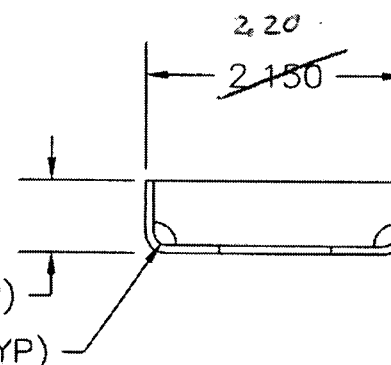
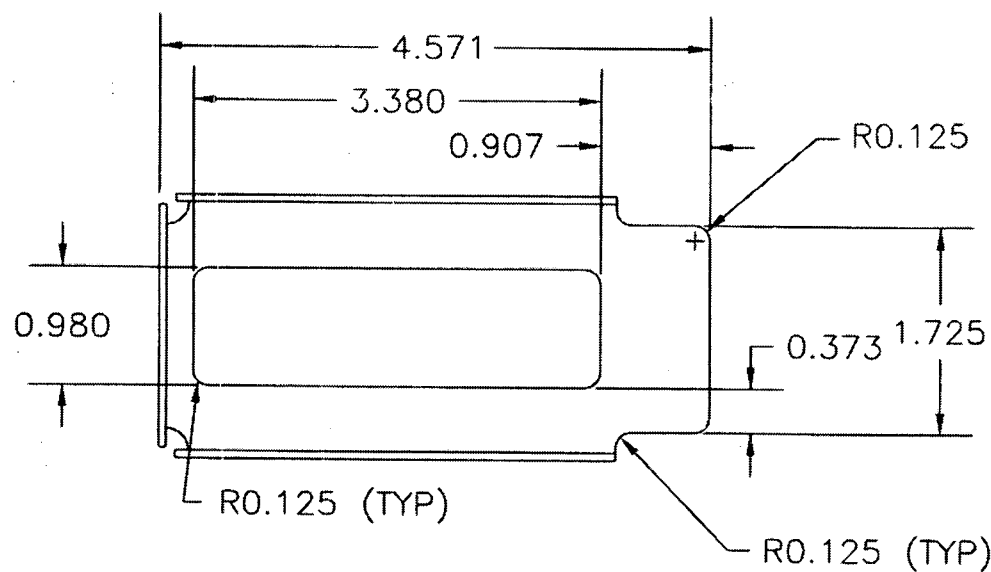
**DART**



RELEASED  
KE 99.02.25

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44775

*BS101217* KE 99.02.26



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
MIKE M.	RF	
CHECKED	APPROVED	DRAWING NO.
<i>JP</i>	<i>KE</i>	D2583
DATE	TITLE	SHEET 1 OF 1
99.02.22	LATCH BRACKET	SCALE
		2:3
REV.	DATE	DESCRIPTION
A	96.07.10	NEW ISSUE
B	99.02.22	CHANGE OF FINISH (PER TSR A887)

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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